Dart Aerospace Ltd. Friday, 9/29/2006 10:43:16 AM Date: Kim Johnston User: **Process Sheet** : SPACER Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 28791A : 10352 **Estimate Number** :NIA : D2280 Part Number P.O. Number S.O. No. : NA : 9/29/2006 D2280 REV D **Drawing Number** This Issue Prsht Rev. **Project Number** : N/A : NM Type : SMALL /MED FAB : D First Issue **Drawing Revision** :NIM : 27756A Material **Previous Run** : 10/10/2006 40 Um: Qty: Each **Due Date** Written By Checked & Approved By : Est Rev:A New Issue 05-11-07 JLM Comment **Additional Product** Job Number: **Machine Or Operation:** Description: Seq. #: M6061T6B0250X01000 6061-T6 Bar .25" x 1.0" 1.0 Comment: Qty.: 0.2975 f(s)/Unit Total: 11.8986 f(s) Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1.000)Identify as D2280 Batch: M 18237 SHEAR SHEAR 2.0 Comment: SHEAR 40 Cut blank: (3.400") +/-0.020" 3.0 HAAS CNC VERTICAL MACHINING Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2280 and Dwg D2280 2-Deburr Then Tumble INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40

QC8 SECOND CHECK

Comment: SECOND CHECK



6/10/20 x



5.0

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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #: Fault Category:		NCR: Yes	No. DO	A. 17	h Data: /	26/12/24		

QA: N/C Closed: ____ Date: ____

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	A =======			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:43:16 AM User: Kim Johnston **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 28791A Part Number: D2280 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 POWDER COAT/CHEMICAL CONVERSION 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 9.0 Comment: FINAL INSPECTION/W/O RELEASE N 20-10-24 Job Completion

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W/O:		7	WC	ORK ORDER CHANGE	S				
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NCR:		. \	WORK ORDI	ER NON-CONFORMAN	ICE (NCR)	-		
DATE	STEP	Description of NC	cription of NC Corrective				ition	Approval	Approval
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 287	191 A
Description: Spacer	Part Number: D22	80
Inspection Dwg: D2280 Rev: D	Page 1	of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
	1/0.010		. /			
0.150	+/-0.010	,/53"	$-\mathcal{U}_{/}$			
0.236	+/-0.010	,232"	V/			
3.270	+/-0.010	3 276"	V			
3.020	+/-0.010	3,025"	V ,			
2.135	+/-0.010	2,144"				
1.135	+/-0.010	1.143"				
0.250	+/-0.010	.258"				
1.00	+/-0.030	,999"				
Ø0.128	+0.005/-0.000	Ø //31"	i/			
Ø0.213	+0.005/-0.000	0,215"	V			
C'sink 0.250 x 90°	+/-0.010	,260"				

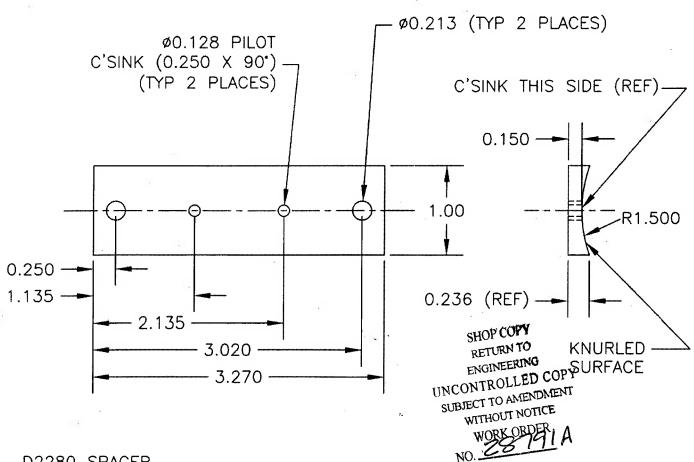
						(A)

Measured by: 5	Audited by:	J.6	Prototype Approval:	N/A
Date: 06/10/18	Date:	06/10/18	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.10.12	New Issue	P/O D2582	KJ/JLM 1.A	21
В	06.03.08	Dwg Rev changed		KJ/JLM 🚓	



DESIG	"AL	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	KED M	APPROVED A	DRAWING NO. REV. I
	#	-11	D2280 SHEET 1 OF
DATE			TITLE SCALI
05.1	1.14		SPACER 1:
Α		94.10.14	NEW ISSUE
В		95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20
С		98.09.29	0.188 DIA HOLE CHANGED TO 0.213
D		05.11.14	ADD FINISHING NOTE



D2280 SPACER

- MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000 (REF. DART SPEC M6061T6B1.000X00.250)
- ACID ETCH AND ALODINE PER DART QSI 005 4.1 2)
- 3) ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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